

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021046**Date Inspected:** 08-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yang Bai Qiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Splice Plate**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG, Bay 1

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as E2-SB2-008-026, located on Steel Barrier E2-SB2-008, welder is identified as 216872, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as E2-SB2-031-088, located on Steel Barrier E2-SB2-008, welder is identified as 216575, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as E2-SB2-048-057, located on Steel Barrier E2-SB2-048, welder is identified as 203710, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

OBG Bay #28

WELDING

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as E5-SB13-004-028, located on Splice Plate, E5-SB13-004, welder is identified as 062259, ZPMC Quality Control (QC) is identified as Mr. Yang Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as W5-SB1-085-026, located on Steel Barrier, W5-SB1-085, welder is identified as 218995, ZPMC Quality Control (QC) is identified as Mr. Ma qian li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as W5-SB1-111-026, located on Steel Barrier, W5-SB1-111, welder is identified as 261879, ZPMC Quality Control (QC) is identified as Mr. Ma qian li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as W5-SB1-106-109, located on Steel Barrier, W5-SB1-106, welder is identified as 206296, ZPMC Quality Control (QC) is identified as Mr. Ma qian li. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as W5-SB1-094-026, located on Steel Barrier, W5-SB1-094, welder is identified as 201074, ZPMC Quality Control (QC) is identified as Mr. Ma qian li. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

FCAW welding of weld joint identified as W5-SB20-003-063, located on Steel Barrier, W5-SB20-003, welder is identified as 066179, ZPMC Quality Control (QC) is identified as Mr. Ma qian li. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

OBG BAY 28

NDT

The following NDT performed ZPMC NDT notification 07691:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 15:45 hours. The members are identified as follows: SA3061B-14-003

SA3061B-15-003, SA3061B-16-003, SA3061B-17-003, SA3061B-18-003, SA3061B-19-003, SA3061B-20-003, SA3061B-21-003, SA3061B-22-003, SA3061B-23-003, SA3061B-24-003, SA3061B-25-003, SA3061B-26-003, SA3061B-27-003, SA3061B-28-003, SA3061B-29-003, SA3061B-30-003, SA3061B-31-003, SA3061B-32-003, SA3061B-33-003, SA3061B-34-003, SA3061B-35-003, SA3061B-36-003, SA3061B-37-003, SA3061B-38-003, SA3061B-39-003, SA3061B-40-003, SA3061B-41-003, SA3061B-42-003, SA3061B-43-003, SA3061B-44-003.

OBG Bay # 1

NDT

WELDING INSPECTION REPORT

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The following NDT performed ZPMC NDT notification 07680:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 8:40 hours. The members are identified as follows:

E2-SB14A-001-050, E2-SB14A-020-050, E2-SB14A-028-050, E2-SB14A-022-050, E2-SB14A-006-081,
E2-SB14A-013-081, E2-SB14A-051-081, E2-SB14A-037-050, E2-SB14A-018-019, E2-SB14A-026-019,
E2-SB14A-010-019, E2-SB14A-035-019, E2-SB14A-034-019, E2-SB14A-030-081
E2-SB14A-004-019, E2-SB14A-040-050, E2-SB14A-036-081.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Humphrey, Delbert | Quality Assurance Inspector |
| Reviewed By: | Hall, Steven | QA Reviewer |
